

Work Order ID 65301

January 11, 2011 9:20:53 AM



Page 1

Item ID: D350-578-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Bearpaw

Start Date: 1/18/11 Start Qty: 10.00



Cust Item ID:

Required Date: 1/31/11 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2432

Rev F3

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D350-578-011 CHG005

Silvaloy

CL 11-02-03

160

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

4/2/3 (10)

170

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

Silvaloy

(410)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 65301

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Item ID: D350-578-011

Accept



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Revision ID:

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Item Name: Bearpaw

Start Date: 1/18/11 Start Qty: 10.00



Cust Item ID:

Required Date: 1/31/11 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP 011 □ Location: <u>11</u>	D350-578-							
190 	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

*REUT**NAV A**Copy 4**11/02/07**ME 11-02-04*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 11, 2011 9:20:52 AM

Page 1

Work Order ID: 65301

Parent Item: D350-578-011

Parent Item Name: Bearpaw



Start Date: 1/18/11

Required Date: 1/31/11

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A New Issue 07-01-02 JLM
IPP Rev:B 08-01-09 Added Step 2 JLM Verified By:EC
IPP Rev:C 08-10-15 New Manufacturing Method JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN4-17A S #10 Bolt		Purchased	No			160	Each	478.0000	12	120			
<div>Location</div> <div>ST358</div> <div>116419</div> <div>116549</div> <div>Loc Qty</div> <div>478</div> <div>400</div> <div>78</div> <div>Loc Code</div>													
D2182B S #10 Rubber Cushion		Manufactured	No			160	f	193.8960	2.5	25			
<div>Location</div> <div>ST410</div> <div>63413</div> <div>Loc Qty</div> <div>193.896</div> <div>193.896</div> <div>Loc Code</div>													
Cut qty-6 at 5.00" long D2274 S #10 Radius Block		Manufactured	No			160	Each	7.0000	12	120			
<div>Location</div> <div>ST010</div> <div>61361</div> <div>63990</div> <div>Loc Qty</div> <div>7</div> <div>1</div> <div>6</div> <div>Loc Code</div>													
D2432 S #10 206 (24") Bearpaw		Manufactured	No			160	Each	0.0000	20	20			

1116419 1164
116549 78

63413

65047

65302 9/2/7 (10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 11, 2011 9:20:52 AM

Work Order ID: 65301

Parent Item: D350-578-011

Parent Item Name: Bearpaw

Start Date: 1/18/11

Required Date: 1/31/11

Start Qty: 10.00

Required Qty: 10.00

D2438

Manufactured No

160 Each

15.0000

6

160



Clamp



69772

[Signature]

Location

Loc Qty

Loc Code

ST256

15

63999

15

D2529

Manufactured No

160 Each

720.0000

12

120



Washer



[Signature]

Location

Loc Qty

Loc Code

ST017

720

64127

720

MS21042L4

Purchased No

160 Each

4,846.000

12

120



Nut



64127

1/12/3 (40)

Location

Loc Qty

Loc Code

ST300

4846

1123143

2

115589

10

115621

334

116188

3500

116548

1000

1116548

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Picklist Print

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Work Order ID: 65301



Parent Item: D350-578-011



Parent Item Name: Bearpaw

Start Date: 1/18/11

Required Date: 1/31/11

Start Qty: 10.00

Required Qty: 10.00

NAS1149D0463J

Purchased

No

160

Each

3,031.000

24

240



Washer

MI16304

Location

Loc Qty

Loc Code

ST297

2668

116304

2668

ST298

363

110914

4

115622

38

116025

118

116289

203

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

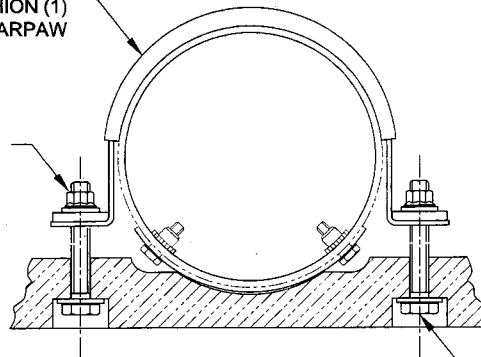
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

REFERENCE ONLY

D2438 CLAMP (1)
D2182B050 RUBBER CUSHION (1)
3 PL PER BEARPAW

MS21042L4 NUT (1)
AN960JD416 WASHER (1)
D2274 RADIUS BLOCK (1)
D2529 WASHER (1)
AN4-17A BOLT (1)
6 PL PER BEARPAW



ADDITIONAL AN960JD416 WASHERS MAY BE INSTALLED UNDER THE NUTS TO ENSURE 1.5-4 THREADS IN SAFETY ON THE BOLTS. ALTHOUGH NOT GENERALLY NECESSARY, IT IS ALSO ACCEPTABLE TO REPLACE THE AN4 BOLTS PROVIDED WITH LONGER OR SHORTER AN4 BOLTS, IF REQUIRED.

Section A-A
Figure 4 – Clamping Detail

5.0 PARTS LIST

Qty -011	Qty -021	Part Number	Description
X		D350-578-011	BEARPAW INSTALLATION
	X	D350-578-021	BEARPAW INSTALLATION
6	6	D2182B050	Rubber Cushion
12	12	D2274	Radius Block
12	12	D2529	Washer
6	6	D2438	Clamp
2		D2432F	Bearpaw
	2	D2672F	Bearpaw
12	12	AN4-17A	Bolt
24	24	AN960JD416	Washer
12	12	MS21042L4	Nut (or MS21042-4)

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Revision: F

Date: 08.08.28